

Date: Wednesday, 1/23/2008 11:36:42 AM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|-----------------------------------------------------------------------|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SPACER BUSHING |
| Job Number | : 36920 | | |
| Estimate Number | : 10823 | | |
| P.O. Number | : | Part Number | : D23271 |
| This Issue | : 1/23/2008 S.O. No. : | Drawing Number | : D2327 REV D |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : MACHINED PARTS | Drawing Revision | : D |
| Previous Run | : 31693 | Material | : |
| Written By | : | Due Date | : 1/30/2008 Qty: 50 Um: Each |
| Checked & Approved By | : <u>08 01 23</u> | | |
| Comment | : Est. D 05.11.02 Removed 303 SS KJ/EC Est Rev:E Removed 303SS JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|------------------|
| 1.0 | M304R0375 | 304 SS ROUND BAR |
|-----|-----------|------------------|



Comment: Qty.: 0.1860 f(s)/Unit Total : 9.2978 f(s)
Inventory

Material: AISI 304 Round Bar Ø0.375"
(M304R0.375)

Batch: M106860

Y.A

08/01/25

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327
Deburr

J.F. / Y.A. / EG

08/01/25 (53)

| | | |
|-----|-----|----------------------------------------|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / Y.A. / EG

08/01/25 (53)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.L 08/01/27

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BARC 44

08/01/28 (53)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/09
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:36:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 36920

Part Number: D23271

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



53

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/29

Job Completion



2008/1/28

53X

W

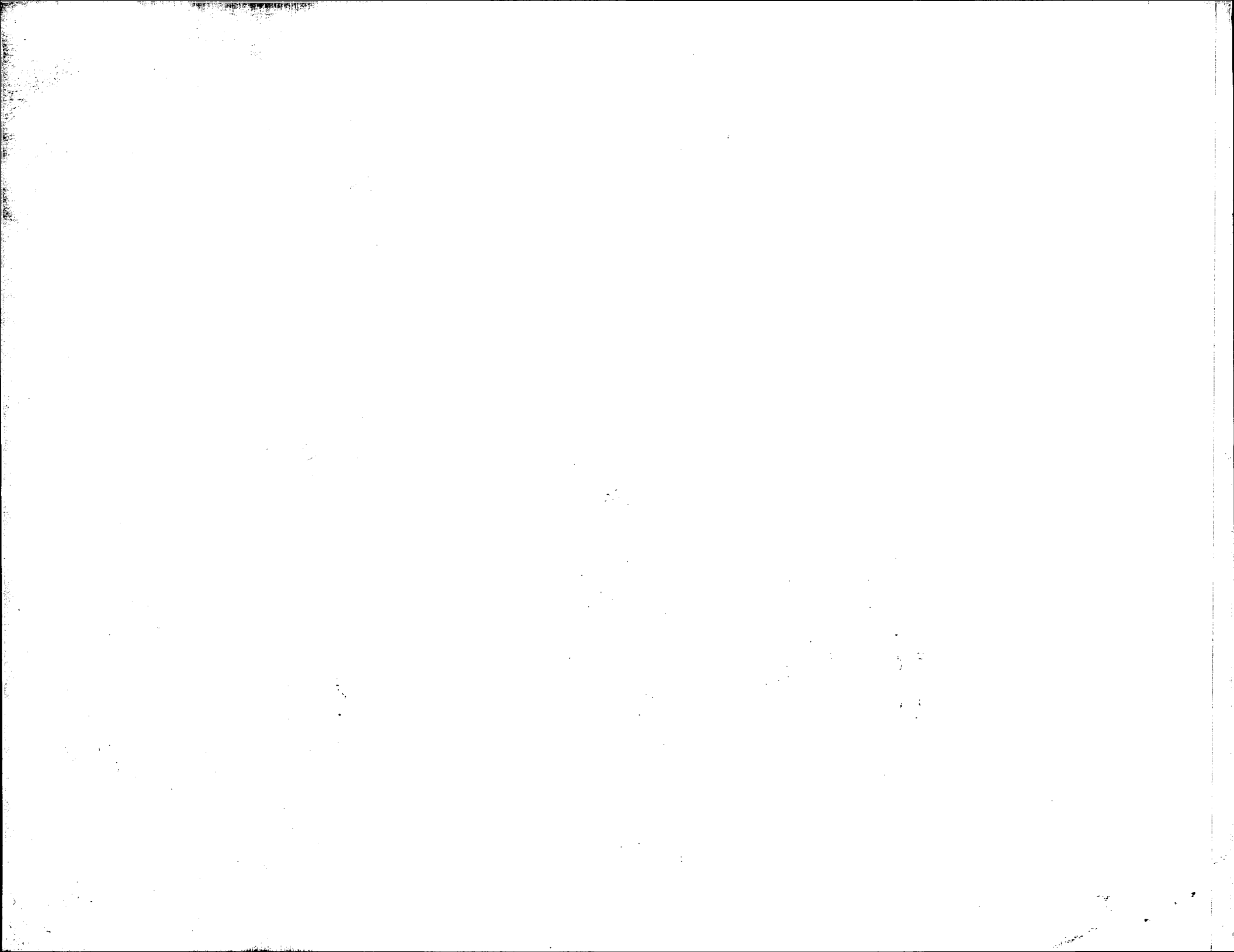
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

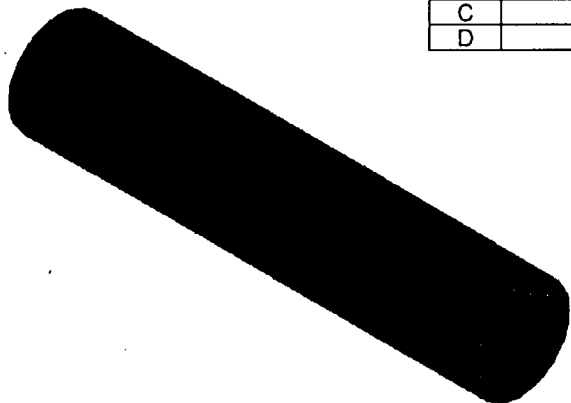
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

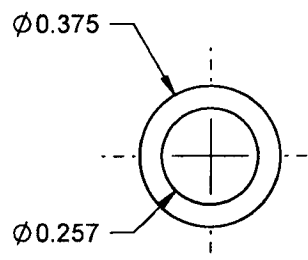
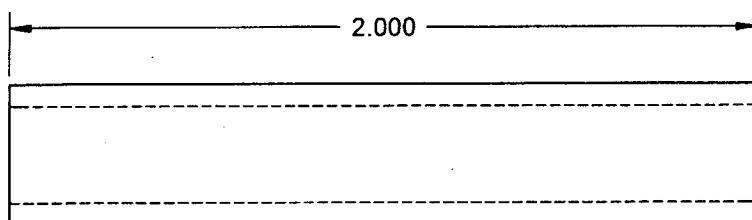




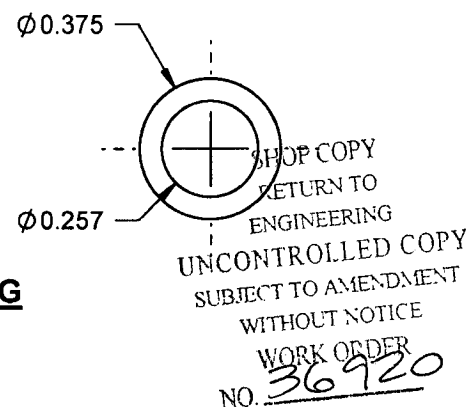
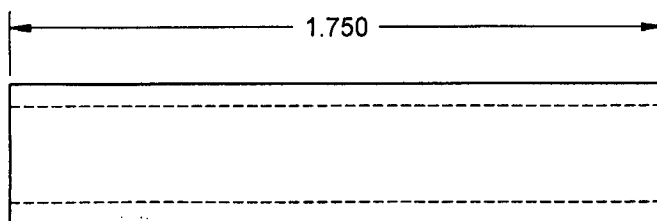
| | | | |
|------------------|----------------|---------------------------------------------------|------------------------|
| DESIGN BW | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED LE | APPROVED H | DRAWING NO. D2327 | REV. D SHEET 1 OF 1 |
| DATE 06.10.12 | | TITLE SPACER BUSHING | SCALE 2:1 |
| REV | DATE | DESCRIPTION | |
| A | 94.12.17 | NEW ISSUE | |
| B | 95.12.06 | LENGTH CHANGE | |
| C | 03.05.13 | 303 SS SPEC ADDED | |
| D | 06.10.12 | REMOVE 303 SS MATERIAL | |



RELEASED
06.11.14



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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